



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 169945



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/4/18

Job Tracking No:

Due Date: 1/26/18

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in born DD 10.04.28 verified by:EC

Ship Via:

* AIR BUS *

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/24/18	1/24/18	0.00	0.00	Start Up Large Fab-4		SL 1/29/18
110	Large Fab	10 pcs	1/25/18	1/25/18	0.00	9.91	Large Fab 2		SL 1/29/18
120	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC9		CPC
130	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC5		CPC
140	HandFinish	10 pcs	1/25/18	1/25/18	0.00	1.84	HandFinish1		2-18/01/30 JSL
150	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC7-2		CPC
180	Large Fab	10 pcs	1/25/18	1/25/18	0.00	9.91	Large Fab 2		SL 1/31/18
190	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC10		CPC
200	QC	10 pcs	1/25/18	1/25/18	0.00	0.00	QC5		CPC
210	HandFinish	10 pcs	1/25/18	1/25/18	0.00	1.84	HandFinish1		18-01-31 JSL
220	Powdercoat	10 pcs	1/25/18	1/25/18	0.00	2.90	Powdercoat1		BL 18-02-2
230	HandFinish	10 pcs	1/26/18	1/26/18	0.00	1.84	HandFinish3		3-EBD18-02-05
240	QC	10 pcs	1/26/18	1/26/18	0.00	0.00	QC3		1 FEB 06 2018
250	Packaging	10 pcs	1/26/18	1/26/18	0.00	0.00	Packaging1-3		6 FEB 06 2018
260	QC	10 pcs	1/26/18	1/26/18	0.00	0.00	QC4		7 FEB 06 2018
265	DC	10 pcs	1/26/18	1/26/18	0.00	0.00	DC		7 FEB 06 2018
270	Packaging	10 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-1		7 FEB 06 2018
280	QC21-FG	10 Ea	1/26/18	1/26/18	0.00	0.00	QC21		7 FEB 07 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 11:45. OVEN TEMPERATURE: 320° FINISH TIME: 12:15.

265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

M 138467

Wing walk M138711

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
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000462

503485789

F9072

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

90-Start up Operation	D3067-1 ✓	10	18	0	0
	D3219-1 ✓	20	54	0	0
	D3272-1 ✓	10	0	0	0
180-Large Fab	D3065-041 ✓	10	14	0	0
	D3066-1 S034838 ⑨	20	90	0	0
	D3067-1 S037090 ⑨	10	18	0	0
	MS20600-AD4W4	160	1,447	0	0
250-Packaging	AN3-35A	20	268	0	0
	AN4-13A	80	1,299	0	0
	AN5-36A	20	194	0	0
	D2230-3	40	179	0	0
	D2618	20	190	0	0
	D2856-400-720	20	185	0	0
	D3235-1	20	67	0	0
	D3278-041	10	23	0	0
	MS21042L3	20	3,336	0	0
	MS21042L4	80	3,684	0	0
	MS21042L5	20	759	0	0
	NAS1149D0363J	40	4,434	0	0
	NAS1149D0463J	160	5,772	0	0
	NAS1149D0563J	40	1,319	0	0

NEED
① MORE

Part Specifications

Specifications could not be found.

Plex 1/4/18 8:40 AM dart.poulin.mario

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
NCR No. _____	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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	Disposition	
		Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

FAULT CATEGORY						
Electric	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
	☐	Contamination	☐	Out of Sequence	☐	Part Moved
	☐	Countersink	☐	Off-set	☐	Drawing
	☐	Cut Too Short	☐	Mislabeled	☐	Finish
e	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence

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CANADA

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DART
AEROSPACE

AEROSPACE

S034857



Heli - Access - Step LH - High Gear, Long Step, Aerazur Float Compatible

PART NO: D350-591-311

Original Serial #: S034857

Revision:

Operation: Start up Operation 01/24/18

CHG002 Job No: 169945

Change No:



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Master Unit 000462

Tel (613) 632-5200

Containers on Master Unit 000462				
Serial No	Part No	Customer Part No	Status	Quantity
S038683	AN3-35A		Allocated	18
S014729	AN4-13A	AN4-13A	Allocated	61
S038682	AN4-13A	AN4-13A	Allocated	11
S033010	AN5-36A	AN5-36A	Allocated	4
S033056	AN5-36A	AN5-36A	Allocated	4
S038681	AN5-36A	AN5-36A	Allocated	10
S007911	D2230-3	D2230-3	Allocated	4
S038674	D2230-3	D2230-3	Allocated	32
S038685	D2618	D2618	Allocated	18
S038684	D2856-400-720	D2856-400-720	Allocated	18
S038671	D3278-041	D3278-041	Allocated	9
S038680	MS21042L3	MS21042L3	Allocated	18
S038679	MS21042L4	MS21042L4	Allocated	72
S038678	MS21042L5	MS21042L5	Allocated	18
S038677	NAS1149D0363J	NAS1149D0363J	Allocated	36
S038676	NAS1149D0463J	NAS1149D0463J	Allocated	144
S038675	NAS1149D0563J	NAS1149D0563J	Allocated	36

D2235-1 5039496 18x

REF. only

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.